

Date: Thursday, 3/30/2006 8:31:05 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|-----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FUEL PURGE CANISTER |
| Job Number | : 26416 | | |
| Estimate Number | : 10440 | | |
| P.O. Number | : N/A | Part Number | : D3262041 |
| This Issue | : 3/30/2006 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D3262 REV B |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : 23284 | Drawing Revision | : B |
| | Type : MACHINED PARTS | Material | : N/A |
| Written By | | Due Date | : 4/30/2006 |
| Checked & Approved By | : <i>See Comment Below</i> | Qty: | 4 Um: Each |
| Comment | : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

26416A

FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

2.0

26416B

FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

3.0

D32621

Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube

Pick:

Qty

Part Number

Description

Batch

1

D-3262-1

Tube

B26416A

RE. 06.05.16 4

4.0

D32623

Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cap

Pick:

Qty

Part Number

Description

Batch

2

D3262-3

Cap

B26416B

RE. 06.05.16 4

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick: Qty

Part Number

Description

Batch

A/R

Aluminum Rod

M19173

RE. 06.05.17 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 8:31:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 26416

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



PD 060609

Comment: WELD INSPECTION

060609 (2)

(10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-06-14

(4)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

O.M 06-06-18

(4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 060616

(2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: */*

06/6/14

(2)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/19

(2)

Job Completion



U 06-06-19

Dart Aerospace Ltd

| W/O: _____ | | WORK ORDER CHANGES | | | | | | |
|------------|------|--|--------------------|----------|-----|-------------------------------------|--------------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 06-06-09 | 6 | Add on inspection to pressure test canisters as per Dwg. Permanent change. <i>[Signature]</i> | <i>[Signature]</i> | 06-06-09 | 4 | <i>[Signature]</i> 06-06-09 | <i>[Signature]</i> 06-06-09 | |
| | | | | | | | | |

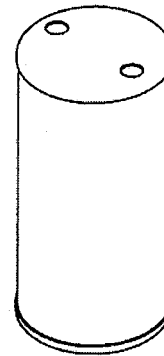
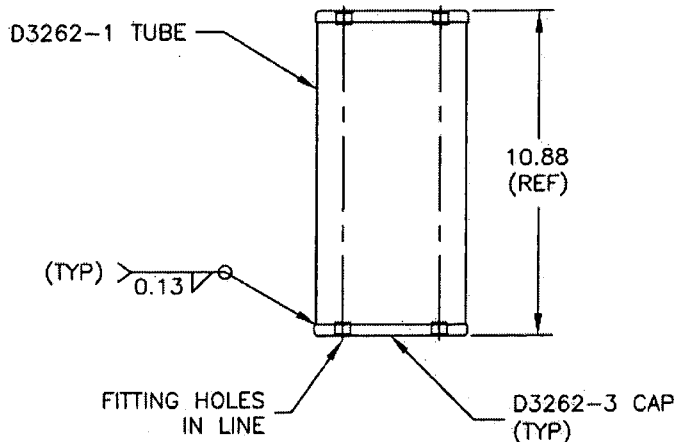
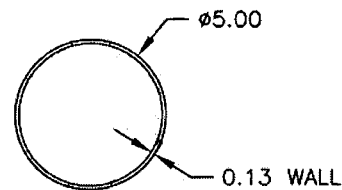
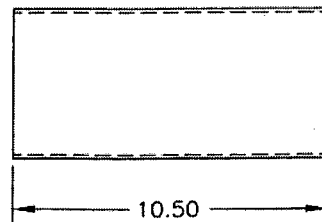
Part No: D3262-3 PAR #: N/A Fault Category: Prod / FAB. AS med-Small NCR: Yes No DQA: [Signature] Date: 06/06/19
 QA: N/C Closed: [Signature] Date: 06-06-19

| NCR: <u>26416</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|-----------------------------|---------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06-06-09 | 5 | TEST for leaks WAS done prior to inspection. Upon installation of bolts to seal of canister, threads were stripped/cross threaded on ports | <i>[Signature]</i> ACTH2 | Scrap: des of 2 canisters. | <i>[Signature]</i> 06-06-09 | <i>[Signature]</i> 06-06-09 | <i>[Signature]</i> 06-06-09 | <i>[Signature]</i> 06-06-09 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN R# | DRAWN BY R# | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H# | APPROVED H# | DRAWING NO. D3262 | REV. B SHEET 1 OF 2 |
| DATE 05.02.14 | | TITLE FUEL PURGE CANISTER | SCALE 1:1 |
| A | 04.05.06 | NEW ISSUE | |
| B | 05.02.14 | ADD PRESSURE TESTING OPTION | |

RELEASED
05.02.14**D3262-041 CANISTER ASSEMBLY****1 D3262-1 TUBE****D3262-041:**

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 100 PSI AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY

RETURN TO
ENGINEERINGCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER
NO. 26416

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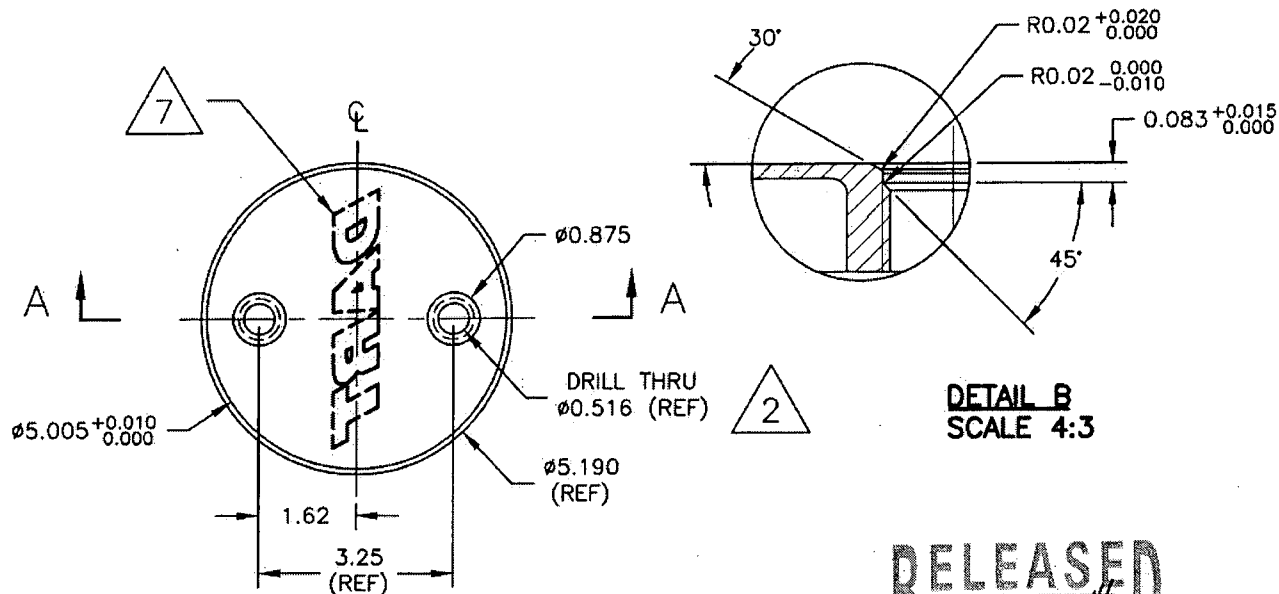
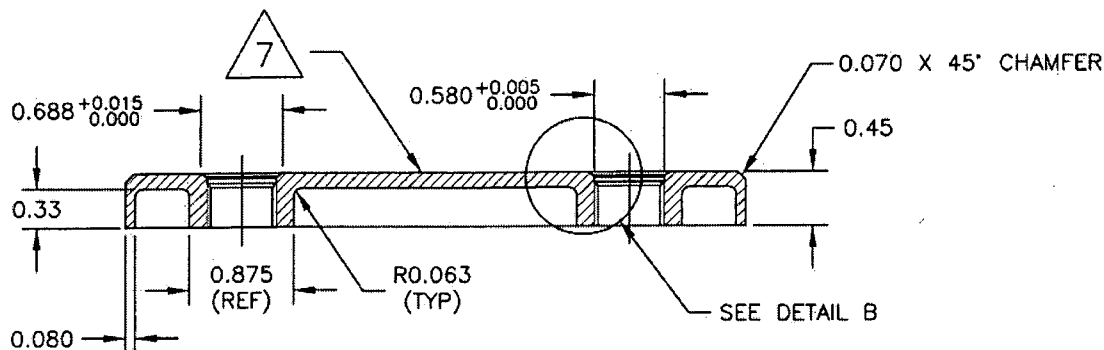
SECRET

508

10

DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN RT | DRAWN BY RT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3262 | REV. B SHEET 2 OF 2 |
| DATE 05.02.14 | | TITLE FUEL PURGE CANISTER | SCALE 1:3 |

**D3262-3 CAP****RELEASED**
05.02.14**D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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